

Work Order ID 81095

March-08-12 8:46:04 AM

81095

Page 1

Item ID: D3391-021
 Revision ID:
 Item Name: Fwd Tube Assembly
 Start Date: 08/03/2012 Start Qty: 1.00
 Required Date: 22/03/2012 Req'd Qty: 1.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: MLJ Date: 12/03/09 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3391 | 1 |

| | | | | | | | | | |
|--------------|--------------------------------------|------|--|--|--|--|--|--|--|
| 100 | | 0.00 | | | | | | | |
| *100* | Skidtubes | | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | Cut extrusion to 46.52 +0.010 -0.020 | | | | | | | | |

③ SAD 12-03-19

| | | | | | | | | | |
|----------------------|---|------|--|--|--|--|--|--|--|
| 110 | | 0.00 | | | | | | | |
| *110* | BENDING MACHINE - SKIDTUBES | | | | | | | | |
| CNC Bend 1 | Memo | 0.00 | | | | | | | |
| CNC Delta 100 Bender | Bend as per Dwg D3391 Using Bend Prog 3391021 | | | | | | | | |

① SAD 12-03-19

| | | | | | | | | | |
|-----------------|---|------|--|--|--|--|--|--|--|
| 120 | | 0.00 | | | | | | | |
| *120* | QC5- Inspect part completeness to step on W/O | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

6.78"

DP 12-3-19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

March-08-12 8:46:04 AM

Page 2

Drill X1 Aft cap as per Dwg D3391 .1875" dia

SL 12-03-22

JK 12-03-22

1 12/03/22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

81095

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

*** 1 ***

Cust Item ID:

*** 1 ***

Customer:

Reference:

Tooling:

Date:

Run Start *NR1*

SPC (Y/N):

Date:

Stop *NR2*

**Insp.
Stamp**

0.00

160

Memo

0.00

Quality Control

0.00

170

Memo

0.00

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 81095

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Item ID: D3391-021 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Tube Assembly
 Start Date: 08/03/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 22/03/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 200 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *200* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |
| 210 | QC7-Inspect Chemical Conversion Coat | 0.00 | | | | | | | |
| *210* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 220 | Skidtubes | 0.00 | | | | | | | |
| *220* | | | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | 1-instal spacers as per dwg D3391 A/R Magnabond 6398 batch: <u>M120666</u> exp. date: <u>13/01/30</u> cure time 12hrs. as per QSI015 2- grind crossbolt flush 3-back drill crossbolt if necessary | | | | | | | | |

Handwritten notes:
 12-5-1
 ① - SAD 12-05-02
 12 12/05/02

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Work Order ID 81095

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Item ID: D3391-021

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Fwd Tube Assembly

Stop ***NS2***

Start Date: 08/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

QC5- Inspect part completeness to step on W/O

0.00

230

QC

Memo

0.00

8/10/08

Quality Control

235

Pressure Wash per QSI005 4.3

0.00

235

HandFinish

Memo

0.00

Hand Finishing

AND REALODINE AS PER PAR09-043

7/6 1258

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

240

Powdercoat

Memo

0.00

Powder Coating

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

10:15
320 01
10:45

1X 12/05/08

M121134

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D3391-021 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Tube Assembly
 Start Date: 08/03/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 22/03/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 250 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *250* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 255 | | 0.00 | | | | | | | |
| *255* | Skidtubes | | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | **** install D3591-1 spacer as per DS19364 and wearplate as per DWG **** | | | | | | | | |
| 257 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *257* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12 05 08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 81095

March-08-12 8:46:04 AM


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Item ID: D3391-021 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Tube Assembly
Start Date: 08/03/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 22/03/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 260 | Identify as per dwg & Stock Location: <u>w/o</u> | 0.00 | | | | | | | |
| *260* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 280 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *280* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12/5/9 MF
12-05-09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81095

81095

Parent Item: D3391-021

D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A05.09.13New issue KJ/JLM
 IPP B06.02.10Dwg rev.D ecn 773 EC
 IPP C06.05.02Added inspections EC
 IPP D 07.03.13 rev F dwg EC
 IPP E 07.11.07 revG dwg ecn1053P EC verified by: DD
 IPP Rev:f ECN 1056 07-11-12 DD verified by: EC
 IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC
 IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC
 IPP Rev I 09.02.02 added hardware EC verified by: DD IPP Rev:J
 11.11.14 AS PER REV.I DD verified by:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|-----------|--|--------------|----|--|--|-----|------|---------|---|----|--------------|--|--|
| D4095-051 | | Manufactured | No | | | 255 | Each | 21.0000 | 1 | 1 | | | |
| | | | | | | | | | | ** | ysl 12/05/08 | | |

D4095-051

Wearpad Assembly

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP001 | 11 | |
| 78821 | 11 | |
| FP002 | 10 | |
| 78914 | 10 | |

| | | | | | | | | | | | | | |
|-----------|--|--------------|----|--|--|-----|------|----------|---|----|--------------|--|--|
| D6013-047 | | Manufactured | No | | | 100 | Each | 110.0000 | 1 | 1 | | | |
| | | | | | | | | | | ** | 3AD 12-03-19 | | |

D6013-047

Skidtube Material

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG | 110 | |
| 72505 | 110 | |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81095

Parent Item: D3391-021

Parent Item Name: Fwd Tube Assembly

81095

D3391-021

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

220

Each

63.0000

4

4

D3670-4-200

SPACER

**

PL 12/65/02

Location

Loc Qty

Loc Code

LG001

63

~~72851~~

3

~~72850~~

4

~~78606~~

56

B72651

(4) (3)
(1)

D3401-041

Manufactured No

255

Each

14.0000

1

1

D3401-041

Tow Cap Assembly

**

HL uloslog

Location

Loc Qty

Loc Code

FP002

14

78990

11

80611

3

1382302

X1

AN960C10L

NAS1149C0332

Purchased

No

255

Each

0.0000

10

10

*AN960C10I * *

washer

11121509 **

(10) HL uloslog

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Work Order ID: 81095

81095

Parent Item: D3391-021

D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

255

Each

3,729.000

10

10

AN3C4A

BOLT

**

yl 12/05/08

Location

Loc Qty

Loc Code

ST350

3729

117688

5

118112

16

119749

10

120187

2000

120423

10

120521

510

120769

515

120799

163

120930

500

x10

D3672-1

Manufactured

No

255

Each

1,294.000

4

4

D3672-1

Phenolic Washer

**

yl 12/05/08

Location

Loc Qty

Loc Code

FP001

242

66821

242

ST060

1052

72229

52

76277

500

80369

500

x4

AELS-1032-225

Purchased

No

255

Each

0.0000

10

10

AFI S-1032-225

INSERT

**

(x10) yl 12/05/08

* AELS-1032-225 / 11121269

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

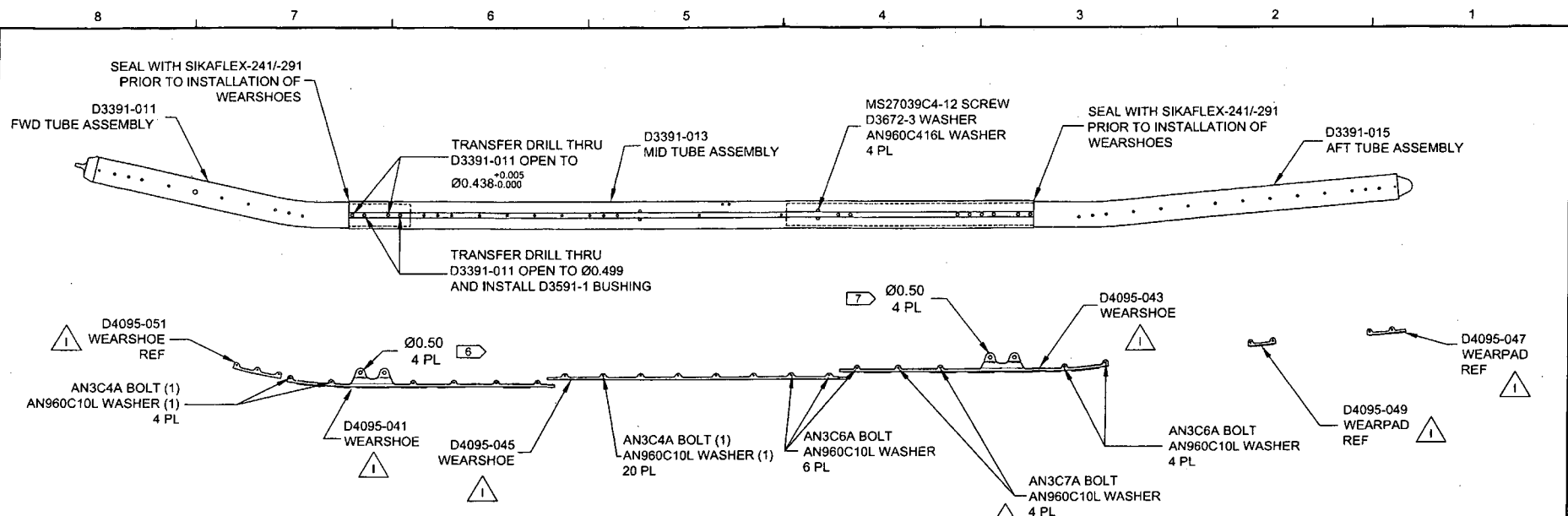
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D3391-041 ASSEMBLY

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

RELEASED
2011-11-04
ECN# 11-662

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

| QTY | PART NUMBER | DESCRIPTION |
|------|--------------|-------------------------|
| -041 | | |
| X | D3391-041 | FLOAT SKIDTUBE ASSEMBLY |
| 1 | D3391-011 | FWD TUBE ASSEMBLY |
| 1 | D3391-013 | MID TUBE ASSEMBLY |
| 1 | D3391-015 | AFT TUBE ASSEMBLY |
| 2 | D3591-1 | BUSHING |
| 4 | D3672-3 | WASHER |
| 1 | D4095-041 | WEARSHOE |
| 1 | D4095-043 | WEARSHOE |
| 1 | D4095-045 | WEARSHOE |
| 1 | D4095-047 | WEARPAD |
| 1 | D4095-049 | WEARPAD |
| 1 | D4095-051 | WEARSHOE |
| 24 | AN3C4A | BOLT |
| 10 | AN3C6A | BOLT |
| 4 | AN3C7A | BOLT |
| 38 | AN960C10L | WASHER |
| 4 | MS27039C4-12 | SCREW |
| 4 | AN960C416L | WASHER |

GENERAL NOTES

- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

| | | | |
|------------|---|-----|----------|
| I | REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8 | XDF | 11.10.13 |
| H | DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074) | AJS | 08.08.20 |
| G | REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY | DC | 07.07.31 |
| F | ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011-021 | PH | 07.01.18 |
| E | CHANGE TOLERANCE, EASE MANUFACTURE | PH | 06.04.25 |
| D | UPDATE TOLERANCE, CHANGE HOLE SIZE | PH | 06.01.23 |
| C | LENGTHEN AFT EXTENSION | PH | 05.09.27 |
| B | DRAWING UPDATES | PH | 05.06.10 |
| A | NEW ISSUE | PH | 05.02.07 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | PH | | |
| DRAWN | XDF | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 11.10.13 | | |

DART AEROSPACE USA, INC
KENT, WA

DRAWING NO. REV. I
D3391 SHEET 1 OF 8
TITLE SCALE
412 FLOAT SKIDTUBE NTS

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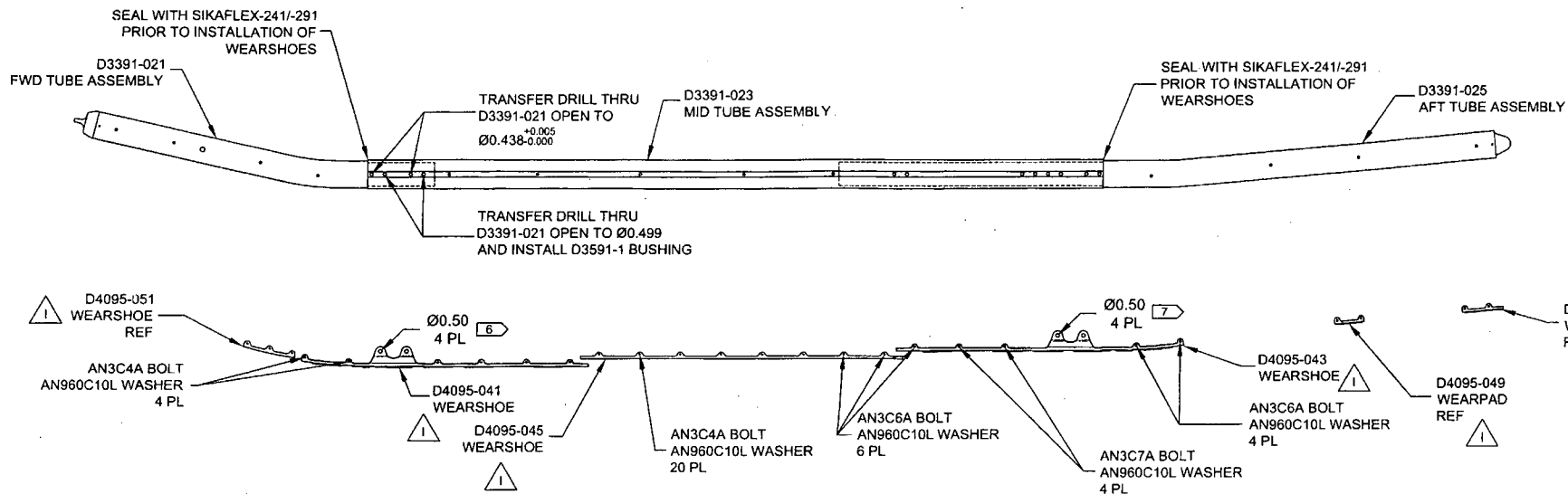
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

| QTY -043 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------------------|
| X | D3391-043 | Float Skidtube Assembly |
| 1 | D3391-021 | FWD Tube Assembly |
| 1 | D3391-023 | MID Tube Assembly |
| 1 | D3391-025 | AFT Tube Assembly |
| 2 | D3591-1 | Bushing |
| 1 | D4095-041 | Wearshoe |
| 1 | D4095-043 | Wearshoe |
| 1 | D4095-045 | Wearshoe |
| 1 | D4095-047 | Wearpad |
| 1 | D4095-049 | Wearpad |
| 1 | D4095-051 | Wearshoe |
| 24 | AN3C4A | Bolt |
| 10 | AN3C6A | Bolt |
| 4 | AN3C7A | Bolt |
| 38 | AN960C10L | Washer |

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
- 3) AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C-BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 7) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 8) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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| MFG. APPR. | | | | D3391 SHEET 2 OF 8 | |
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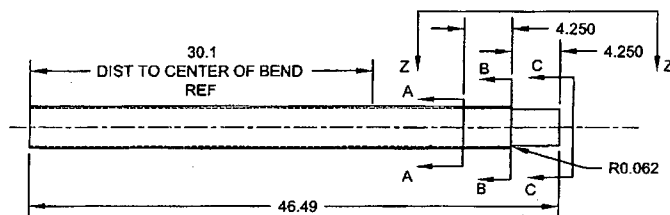
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

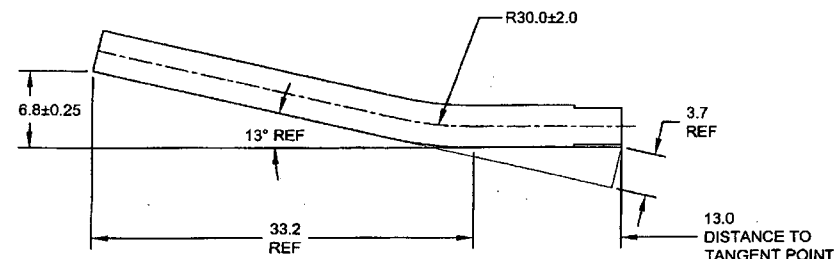
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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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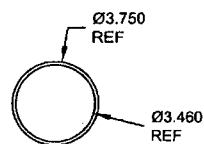
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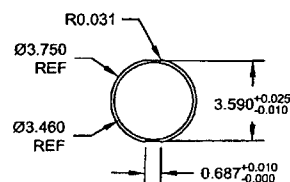
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(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



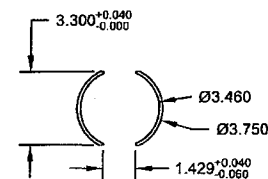
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



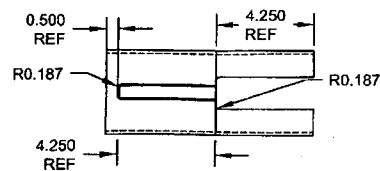
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

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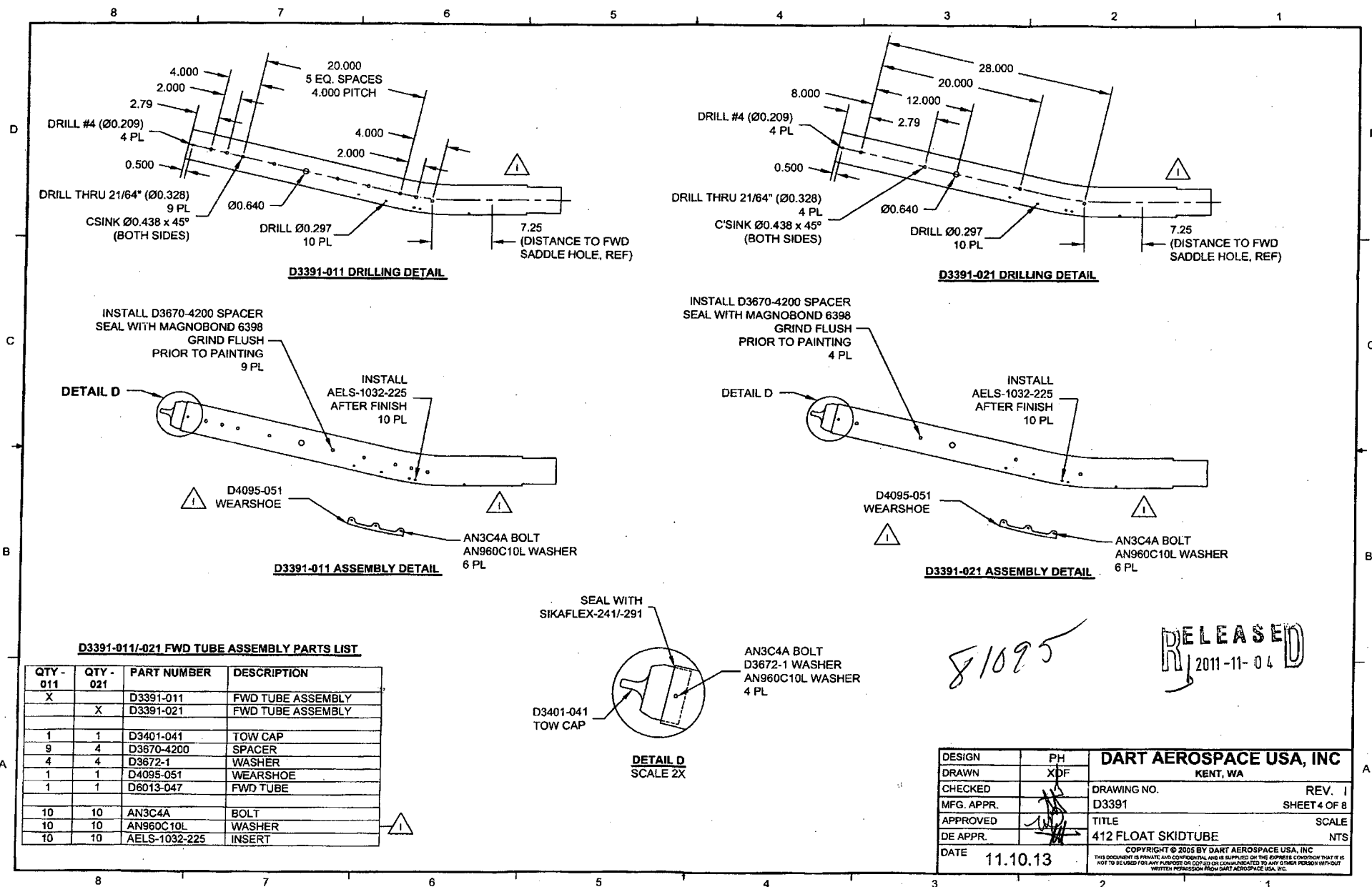
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



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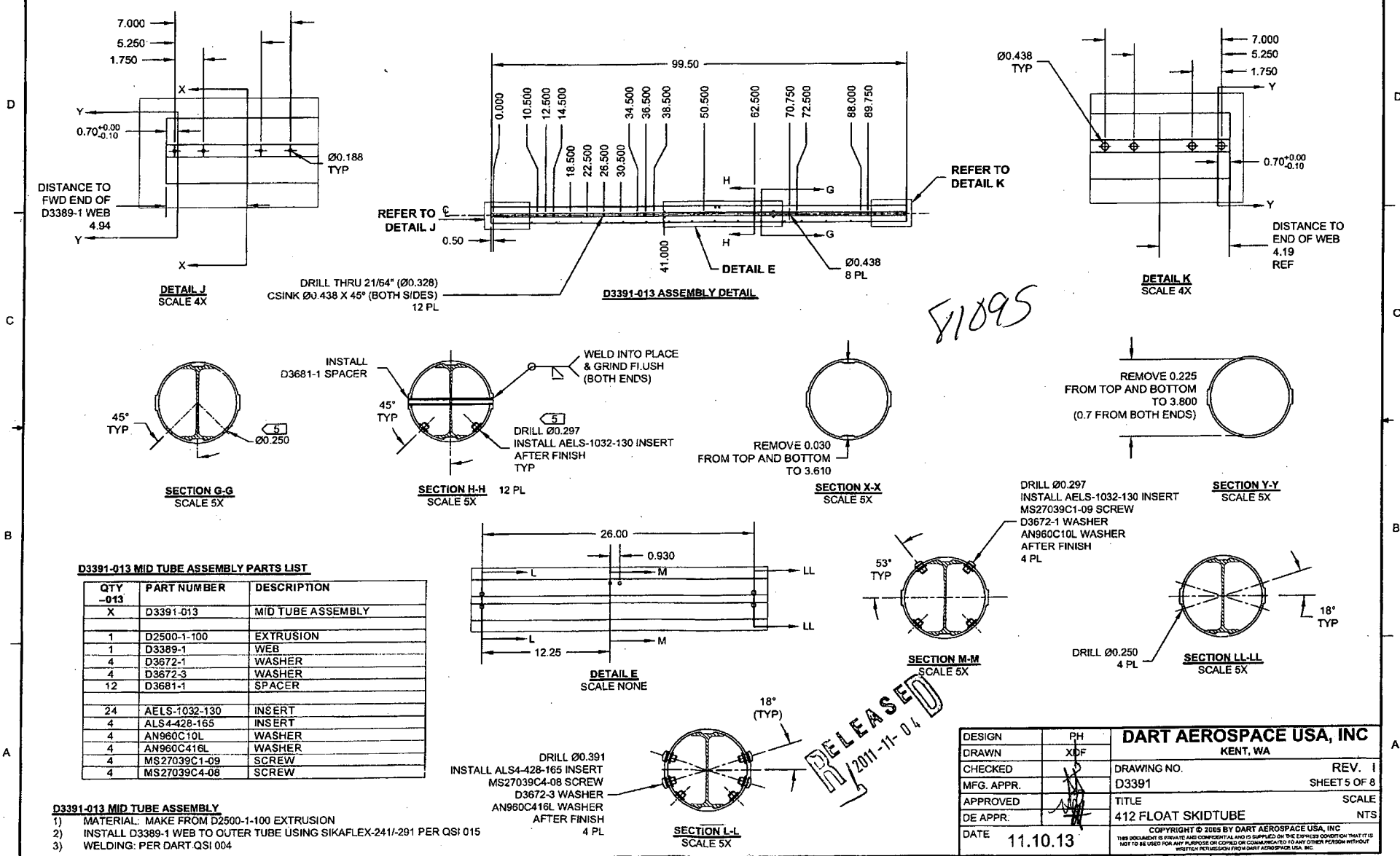
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
NOTE: Date & initial all entries

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11/2011-11-04

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| MFG. APPR. |  | D3391 | SHEET 5 OF 8 |
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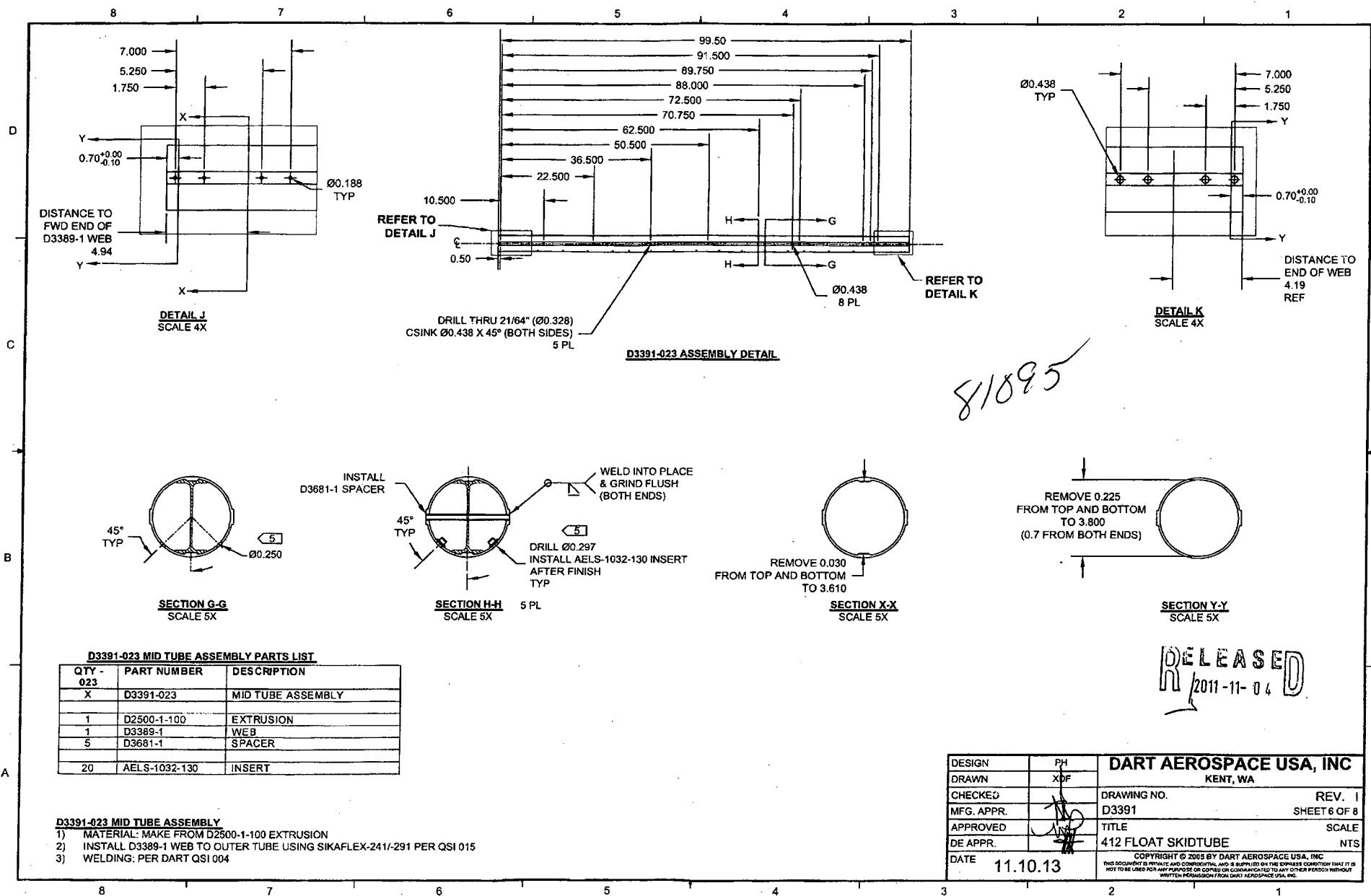
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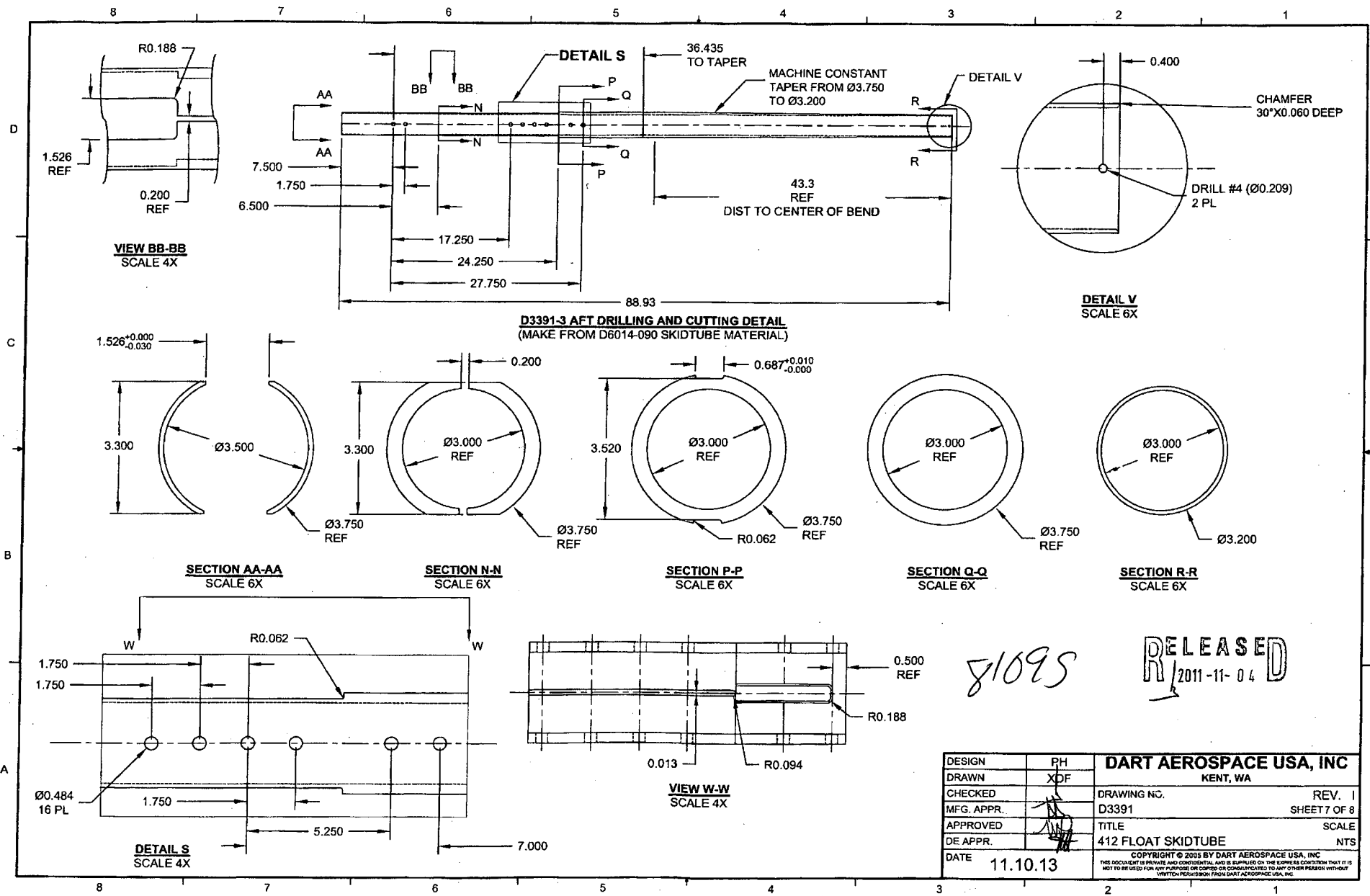
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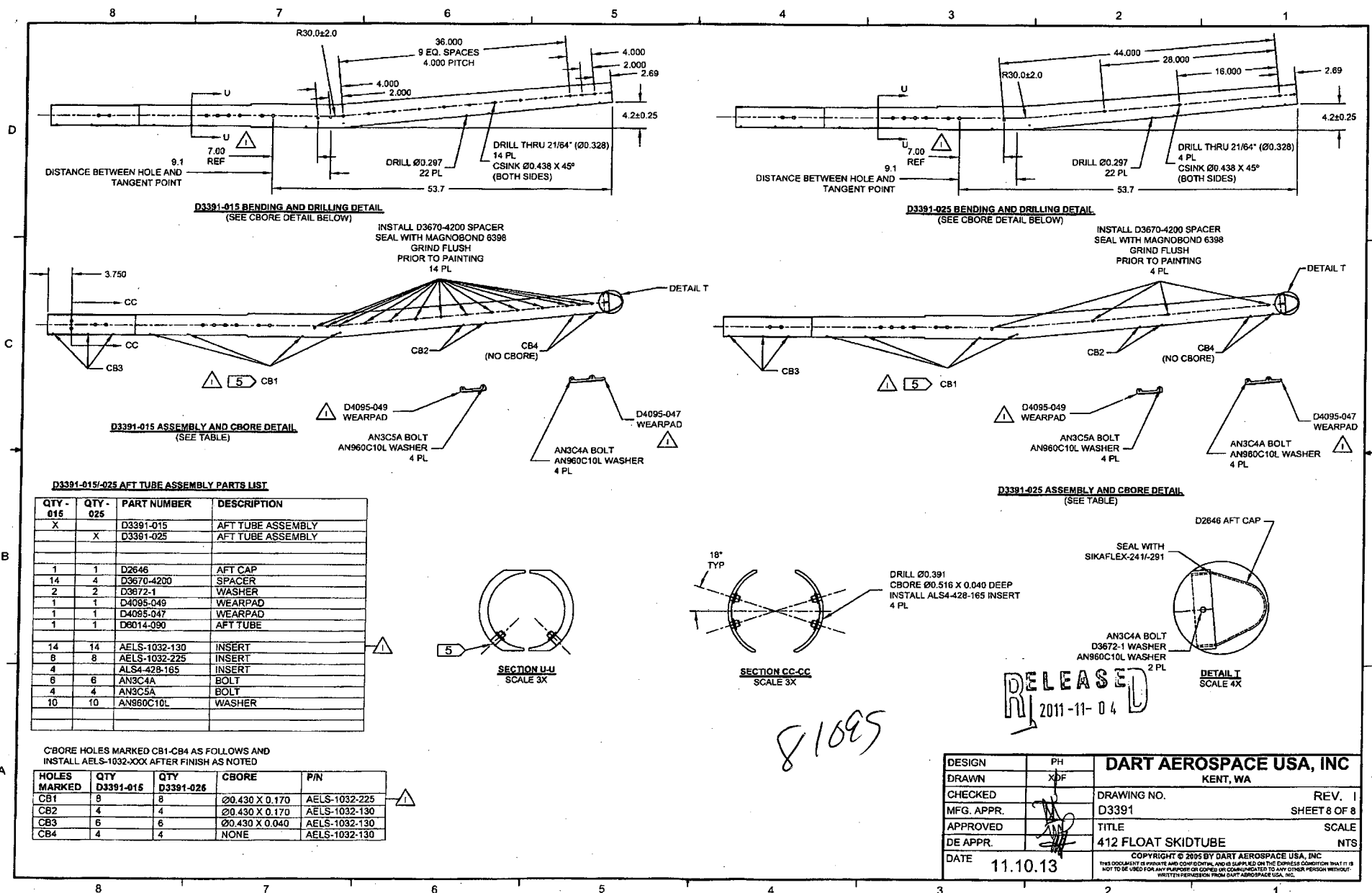
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